

# Work Order ID 64443

Monday, December 06, 2010 10:19:11 AM

Page 1

Item ID: D2530

Accept

Setup Start

Revision ID:

Stop

Item Name: Handle Weldment

Start Date: 12/6/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan: *mt*

Date: *10-12-06* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2530

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut to length as per Dwg D2536  
2-Debur

*=> mtl w/12/06*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*QC6*

*10 12 09 8*

120

Weld per dwg A/R S.S. rod Batch: *111585*

0.00



Small Fab

Large Fab

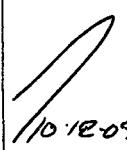
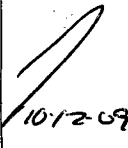
Memo

0.00

Large Fab

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

*lpc 10.12.13*

W/O: 64443		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-12-09	110	Please change to QC 6. for dimension check  perm change	H	11.01.07		 10/12/09	 10/12/09

Part No: D2530 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 64443**

Monday, December 06, 2010 10:19:11 AM



Page 2

Item ID: D2530

Accept



Setup Start



Revision ID:

Stop



Item Name: Handle Weldment

Start Date: 12/6/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.01.06



BE 11/01/06

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/01/06



150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M 112588

Memo

0.00

Powder Coating

START TIME: 11:05  
OVEN TEMPERATURE: 320°  
FINISH TIME: 11:35

8 BR 11-01-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64443**

Monday, December 06, 2010 10:19:11 AM

Page 3

Item ID: D2530

Accept

Setup Start

Revision ID:

Stop

Item Name: Handle Weldment

Start Date: 12/6/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 8.00



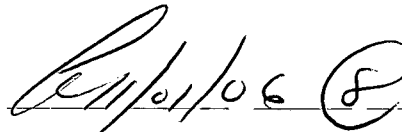

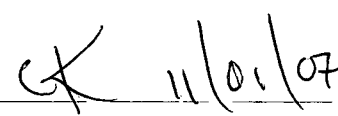
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00		⇒ M 11/01/06		8	0		
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>SUB</u>  Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							 MF 11-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, December 06, 2010 10:19:15 AM

Page 1

Work Order ID: 64443

Parent Item: D2530

Parent Item Name: Handle Weldment

Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TR0.750W.049

Purchased

No

100

f

296.3008

2.9145

24.54316



304 RD Tube .750 x .049W

*m-l 12/12/09*

## Location

## Loc Qty

## Loc Code

MAT

281.680755

108498

0

110113

0

114482

6.6065

115010

15.074255

116108 ✓

260

*24.54316*

MAT014

0.00003

115990

0.00003

MAT017

14.62

109314

9.33

110113

5.29

D2534

Manufactured

No

120

Each

12.0000

2

16



Lock Plate



*Cpl 10-12-13*

## Location

## Loc Qty

## Loc Code

WA020

12

64015

12

*(12)*

*B 64925 → (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



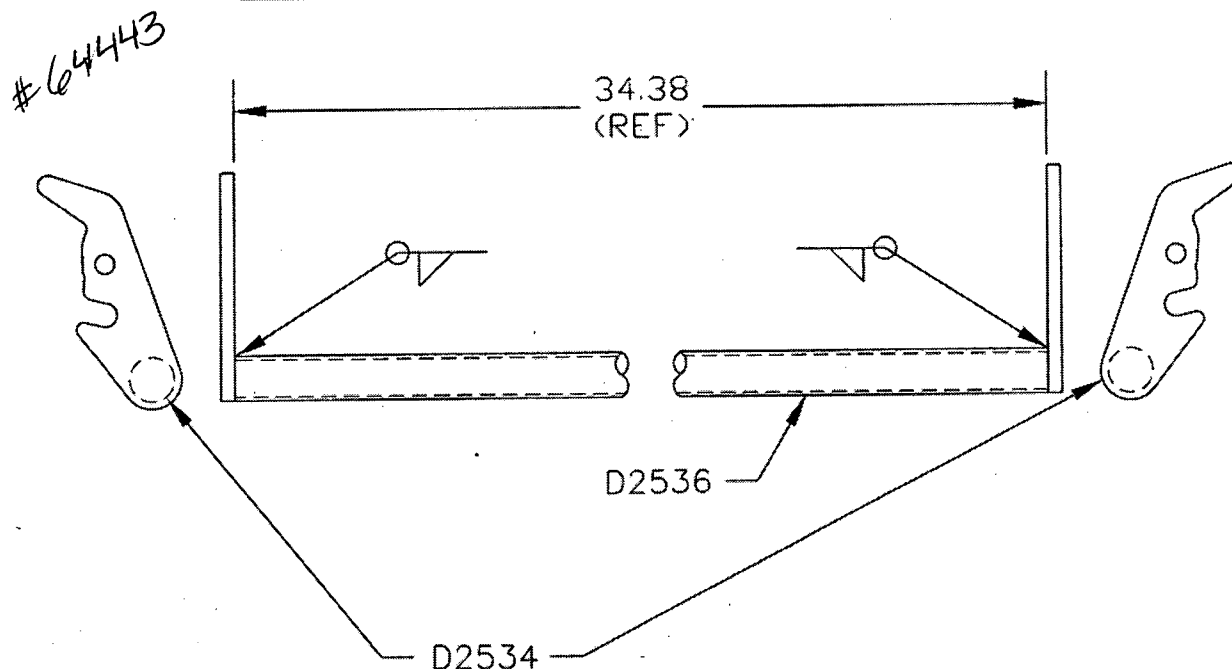
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. B
		D2530	SHEET 1 OF 1
DATE	TITLE		
04.12.14	HANDLE WELDMENT		
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED